

54252. Delu

Work Order ID 52847



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October 15, 2009 12:37:29 PM

Item ID: D2666-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 15/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PP*

Date: 09/10/15 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2666

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. ☐ 1- Inspect part number and batch number are programmed correctly. ☐ 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

SL / mmw
09/12/01

6

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 09/12/01

6

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL / mmw 09/12/01

6

0

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Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



air 09/12/02

6 6

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



WMD 09/12/02

X6

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M 11/2/08

Memo

0.00

BR 09-12-3

6

Powdercoat

START TIME:

10:45

OVEN TEMPERATURE:

FINISH TIME:

11:15

Powder Coating

Handwritten signature

Handwritten mark

Work Order ID 52847

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Item ID: D2666-1

Accept



Setup Start



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Item Name: Saddle, LH Fwd Aft In 206

Start Date: 15/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	U	09/14/03		(X6)	Ø		
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				9/12/4		40 SP	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						09/12/07	MF 09-12-07

Picklist Print

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Work Order ID: 52847



Parent Item: D2666-1RevD



Parent Item Name: Saddle, LH Fwd Aft In 206

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001RevB		Manufactured	No			100	Each	0.0000	6.0000			

Saddle Billet

B46409X6 SL 09/11/30

DART AEROSPACE LTD	Work Order:	52847
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.122	.120	.127	.127		
B	0.100	0.140		.122	.123	.123	.123		
C	2.470	2.510		2.490	2.490	2.488	2.489		
D	0.100	0.180		.130	.130	.130	.133		
E	0.210	0.230		.220	.220	.220	.219		
F	1.313	1.343		1.327	1.329	1.320	1.324		
G	0.240	0.260		.250	.246	.250	.250		
H	0.615	0.685		.650	.650	.660	.660		
I	1.125	1.145		1.136	1.137	1.135	1.135		
J	0.990	1.010		.999	1.001	1.002	1.002		
K	0.235	0.240		.236	.236	.236	.236		
L	0.510	0.515		.511	.511	.511	.511		
M	0.100	0.120		.114	.115	.115	.115		
N	1.565	1.585		1.576	1.579	1.575	1.575		
O	5.990	6.010		6.002	6.004	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.499	2.500		
R	0.490	0.510		.500	.495	.497	.500		
S	0.313	0.318		.314	.314	.318	.318		
T	2.495	2.505		2.500	2.500	2.498	2.499		
U	1.357	1.367		1.362	1.362	1.363	1.362		
V	0.315	0.322		.316	.316	.316	.316		
W	0.540	0.560		.549	.550	.544	.545		
X	1.674	1.684		1.679	1.679	1.679	1.678		
Y	0.257	0.262		.258	.258	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>JK /mmF</i>
Date:	<i>09/12/01</i>

Audited by:	<i>amf</i>
Date:	<i>09/12/02</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	52847
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	# 5	# 6	3	4		
A	0.100	0.140		.127	.127				
B	0.100	0.140		.123	.123				
C	2.470	2.510		2.490	2.486				
D	0.100	0.180		.126	.127				
E	0.210	0.230		.219	.220				
F	1.313	1.343		1.325	1.327				
G	0.240	0.260		.251	.251				
H	0.615	0.685		.656	.651				
I	1.125	1.145		1.133	1.135				
J	0.990	1.010		1.001	1.002				
K	0.235	0.240		.235	.236				
L	0.510	0.515		.511	.511				
M	0.100	0.120		.118	.114				
N	1.565	1.585		1.573	1.575				
O	5.990	6.010		6.004	6.008				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.500	.500				
S	0.313	0.318		.314	.314				
T	2.495	2.505		2.500	2.499				
U	1.357	1.367		1.363	1.362				
V	0.315	0.322		.316	.316				
W	0.540	0.560		.546	.548				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.260	.260				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	mf
Date:	09/12/02

Audited by:	mf
Date:	09/12/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

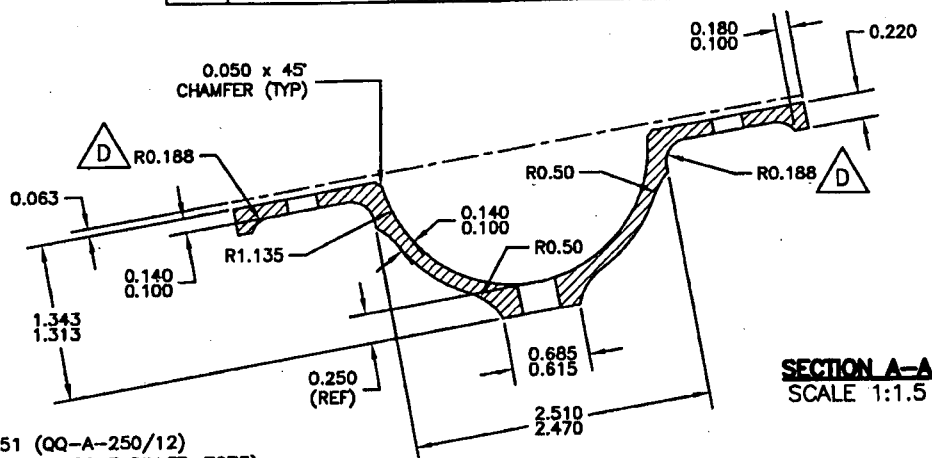
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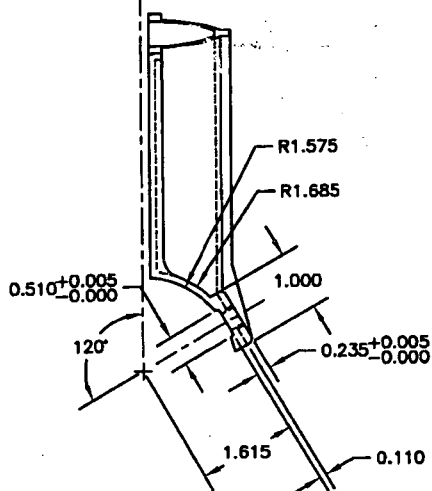
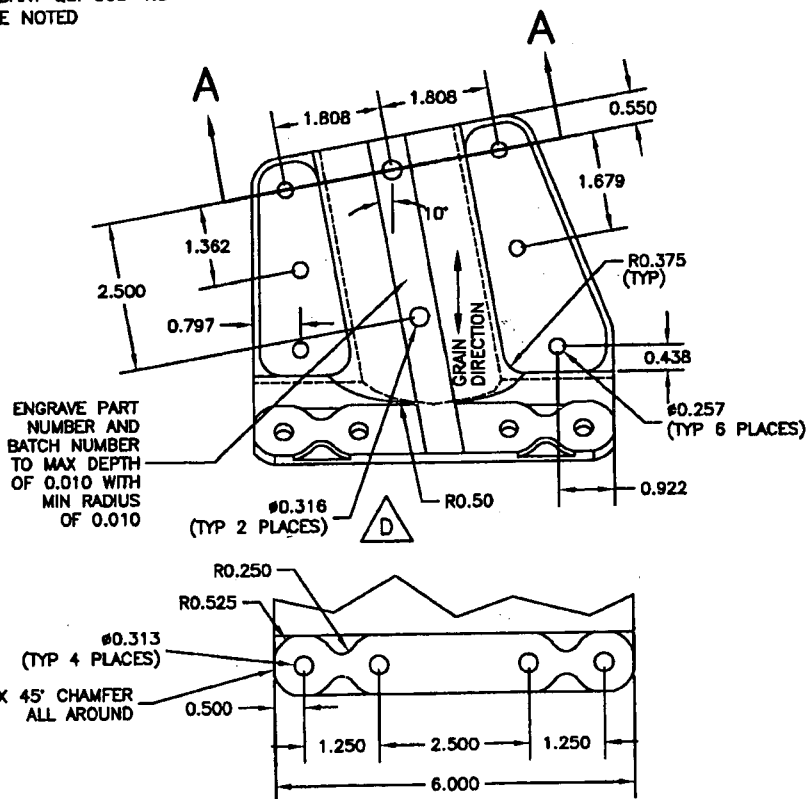
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WORK ORDER
NO. 32847
0910-15

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	RO.188 WAS R0.30; Ø0.316 WAS Ø0.313	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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